

628,022 BLUE

Date: Tuesday, 14/10/2008 1:16:06 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L /407 STEP ASSY, RH
Job Number :	42584A		
Estimate Number :	11703		
P.O. Number :		Part Number :	D2724042
This Issue :	14/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2724 REVC
First Issue :	/ /	Project Number :	
Previous Run :	39838A	Drawing Revision :	C
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	04/11/2008
Written By :		Qty:	2
Checked & Approved By :	JLD 08.10.14	Um:	Each
Comment :	Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion B39316

Check Material for any Dents or Defects

SAD 08/10/16

(2)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

SAD 08/10/16

(2)

3.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch
2 D2734 End Cap B39179

SP 08.10.16 (2X)

4.0 D34581 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3458-1 Plate B36408

SP 08.10.16 (2X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:16:06 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 42584A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-3 Plate

Batch

B364109 SP

08.10.16 (2x)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M10923
M104855

Grind end cap welds flush

SP 08.10.28 (2x)

SP 08.10.28 (2x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 08/10-30 M 08/10/30

(x2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 (x2RH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP

08-10-31

(x2RH)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CAN 08/10/31 (2)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08-11-03 (2x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:16:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 42584A

Part Number: D2724042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: H 104855

SP 08.11.03 (2X)

Grind end plate flush.

SAP 08.11.03 (2)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/03 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.03 (2)

RH's.

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

08/11/03 (2)

Touch up Alodine

M-L

08/11/03

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B 109450

-SPRAY PAINT DELFLEET BLUE

B 105918

-CLEAR DELFLEET

B 109816

m/ 08 09 09 (2)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

RT 08-11-10

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m 109219

FL 08/10/10 (2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 08/11/11 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Job Number: 42584A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



24

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 42584

8/11/11

34

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/11/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
05-11-14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

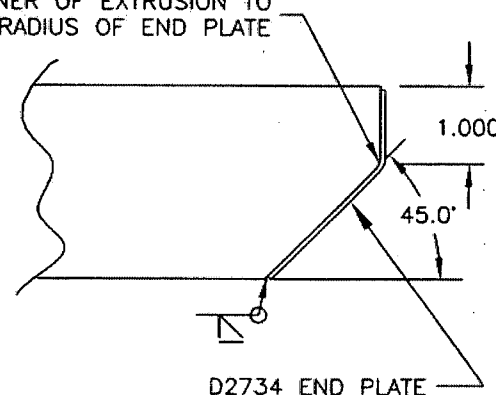
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
425847



TYPICAL STEP END DETAIL
NOT TO SCALE

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